LISTING OF THE CLAIMS

__X__ This listing of claims will replace all prior versions, and listings, of claims in the application:

CLAIMS:

1. (Currently Amended) A fabrication process for a section (11) of an offshore oil production platform support leg (2) member (10), the member (10) comprising a main plate (12) incorporating, on at least one longitudinal edge, teeth (14) forming a rack and at least one stiffener of semicylindrical shape welded to a main surface (12A) of the main plate (12) along two longitudinal edges (16), the stiffener (13) and the plate (12) delimiting a conduit (17), ~~characterized in that~~ wherein it includes the following stages applied to at least one part of the length of the member (10):

a) machining of each longitudinal edge (16) of the stiffener (13) to form, along the longitudinal edge (16), a lip (18) for bearing on the main surface (12A) of the main plate (12) by forming, along the longitudinal edge (16), an external bevel (20) on the side opposite the conduit (17);

b) applying a sole (22) of the bearing lip (18) to the main surface (12A) of the plate (12);

c) heating the bearing lip (18) to ensure its welding to the plate (12) and to form a bearing weld (78); and

d) with filler metal, forming a weld bead (80) from outside the conduit (17) within the space defined between the bearing weld (78), the external bevel (20) and the main surface (12A) of the main plate (12).

2(Currently Amended).- The process as claimed in claim 1, ~~characterized in that~~ wherein the heat supply causing heating of the bearing lip (18) for the purpose of welding it to the plate (12), is ensured from inside the conduit (17).

3. (Currently Amended) - The process as claimed in ~~either of claims 1 and 2~~ claim 1, ~~characterized in that~~ wherein heating of the bearing lip (18) to ensure its welding to the plate (12) is performed without introducing filler metal.

4. (Currently Amended) - The process as claimed in ~~any one of the preceding claims~~ claim 1, ~~characterized in that~~ wherein heating of the bearing lip (18) to ensure its welding to the plate (12) is performed using an inert gas nonconsumable-electrode arc welding method.

5. (Currently Amended) - The process as claimed in ~~any one of the preceding claims~~ claim 1, ~~characterized in that~~ wherein it includes a stage, applied to at least one part of the length of the member (10), involving machining of each longitudinal edge (16) of the stiffener (13) to form an internal bevel (24) on this edge, on the side of the bearing lip (18) facing the conduit (17).

6. (Currently Amended) - The process as claimed in ~~any one of the preceding claims~~ claim 1, ~~characterized in that~~ wherein the weld bead (80) formed from outside the conduit (17) fills completely the space defined between the main surface (12A) of the plate, the external bevel (20) and the bearing lip (18).

7. (Currently Amended) - The process as claimed in ~~any one of the preceding claims~~ claim 1, ~~characterized in that~~ wherein the bearing lip (18) is incorporated within the half of the stiffener (13) thickness (e) situated on the internal conduit (17) side.

8. (Currently Amended) - The process as claimed in ~~any one of the preceding claims~~ claim 1, ~~characterized in that~~ wherein the distance (d) separating the stiffener internal lateral surface (13A), defined on the conduit (17) side, from the bearing lip (18) is between 20 and 40% of the stiffener (13) thickness (e).

9. (Currently Amended) - The process as claimed in ~~any one of the preceding claims~~ claim 1, ~~characterized in that~~ wherein the bearing lip (18) features an internal lateral projection (28) on the conduit (17) side near to its sole (22).

10. (Currently Amended) - The process as claimed in claim 9, ~~characterized in that~~ wherein the minimum height (T) of the projection (28) is between 0 and 8 mm.

11. (Currently Amended) - The process as claimed in ~~either of claims 9 and 10 taken with~~ claim 6, wherein the bearing lip (18) features an internal lateral projection (28) on the conduit (17) side near to its sole (22) and ~~characterized in that~~ wherein a hollow profile (30) is defined between the projection (28) and the internal bevel (24).

12. (Currently Amended) - The process as claimed in ~~any one of the preceding claims~~ claim 1, ~~characterized in that~~ wherein the height (h) of the bearing lip (18) measured at the base of the external bevel (20) is between 6 and 12 mm.

13. (Currently Amended) - The process as claimed in ~~any one of the preceding claims~~ claim 1, ~~characterized in that~~ wherein the width of the sole (22) is between 2 and 15 mm.